

Work Order ID 63855

Tuesday, November 16, 2010 2:49:59 PM



Page 1

Item ID: D4016-3

Revision ID:

Item Name: Hinge Half, Lid

Start Date: 11/16/2010 Start Qty: 6.00

Required Date: 11/23/2010 Req'd Qty: 6.00

Reference:

Approvals:

Process Plan:



Date: 10/16

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr								
D4016	A								

100 Cut blanks as per folio

0.00



Bandsaw

Memo

0.00

A.A 10/11/23

6 Ø

Jeaspa Bandsaw

CUT BLANK as per folio

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLIO FA874 AND DWG
FOLIO REV: AA
DWG REV: A

A.A 10/11/25

6 Ø

DEBURR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 63855

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Item ID:	D4016-3		Accept			Setup	Start			
Revision ID:										
Item Name:	Hinge Half, Lid							Stop		
Start Date:	11/16/2010	Start Qty:	6.00				Cust Item ID:			
Required Date:	11/23/2010	Req'd Qty:	6.00				Customer:			
Reference:										
Approvals:	Process Plan:	Date:	Tooling:	Date:			Run	Start		
	QC:	Date:	SPC (Y/N):	Date:				Stop		
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC2- Inspect parts off machine FAI/FAIB		0.00	M.A	10/11/25		6	0		
130 QC Quality Control	QC8- Inspect parts - second check		0.00	ank	10/11/25		4	0		
160 Packaging Packaging	Identify as per dwg & Stock Location: <u>W/A</u>		0.00	SAD	10-11-30		6			

W/O:		WORK ORDER CHANGES					
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Item ID: D4016-3

Revision ID:

Item Name: Hinge Half, Lid

Start Date: 11/16/2010 Start Qty: 6.00

Required Date: 11/23/2010 Req'd Qty: 6.00

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
Description

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

0.00

Memo

OK 10/12/01 JJ
ME 10-11-01

W/O:		WORK ORDER CHANGES							
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 63855



Parent Item: D4016-3



Parent Item Name: Hinge Half, L.J

Start Date: 11/16/2010

Required Date: 11/23/2010

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 09-11-27 JL VERIFIED BY:DD IPP Rev:B as
per dwg REV.A DD 10.02.22 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B1.000X1.000		Purchased		No		100	f	14.0823	0.08	0.505263			

304 bar 1.00 x 1.00



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT54	14.08227768	
113290	14.0822777	

0.5052 ft 11/16/23

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DART AEROSPACE LTD	Work Order:	48835
Description: Hinge Half, Lid	Part Number:	D4016-3
Inspection Dwg: D4016	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Measured by:	H.A	Audited by:	SMR	Preliminary Approval:	
Date:	10/11/25	Date:	10/11/25	Date:	

Rev	Date	Change	Revised by	Approved
A	10.06.07	New Issue	KJ	

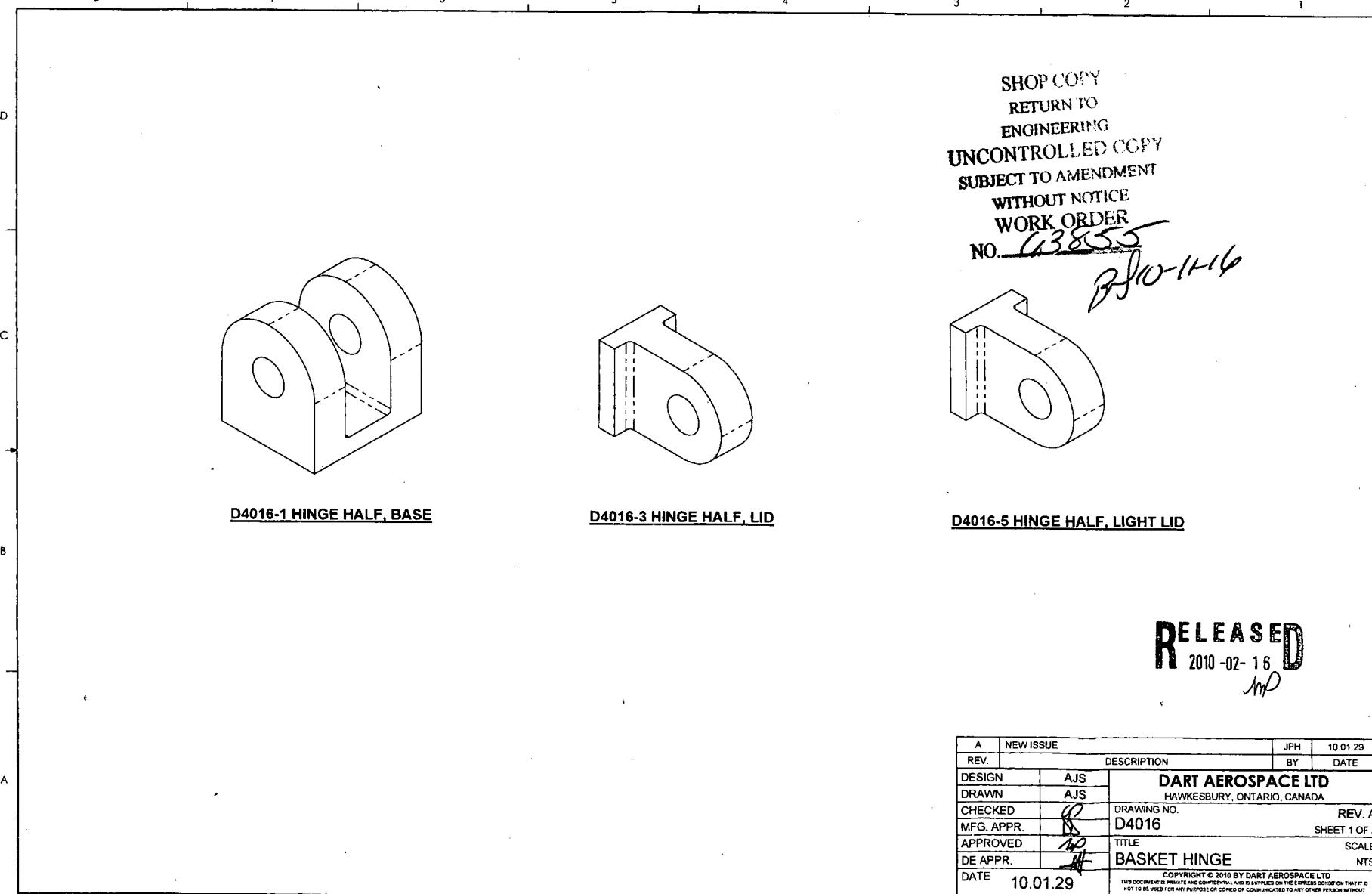
W/O:		WORK ORDER CHANGES					
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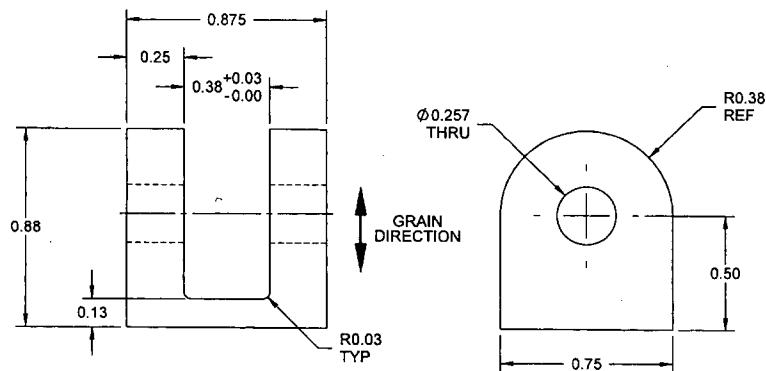
W/O:		WORK ORDER CHANGES					
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D4016-1 HINGE HALF, BASE

NOTES:

1) MATERIAL -1 & -3: 304/316 STAINLESS STEEL BAR, PER ASTM A276
REF DART SPEC M304B

-5: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR,
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

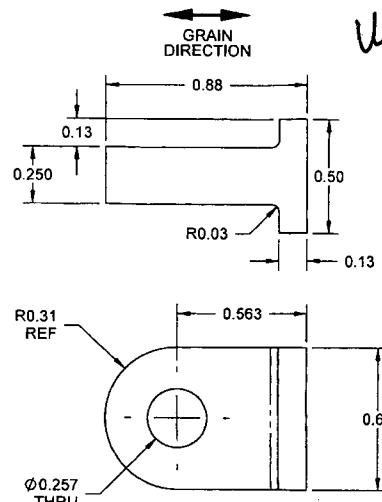
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT -1: 0.09 lbs

-3: 0.04 lbs

-5: 0.01 lbs



D4016-3 HINGE HALF, LID

D4016-5 HINGE HALF, LIGHT LID

RELEASED
2010-02-16
MM

DESIGN	AJS	DART AEROSPACE LTD
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>RR</i>	DRAWING NO.
MFG. APPR.	<i>RR</i>	REV. A
APPROVED	<i>RR</i>	SHEET 2 OF 2
DE APPR.	<i>RR</i>	TITLE
DATE 10.01.29		SCALE NTS

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